

Work Order ID 73337

Wednesday, August 31, 2011 11:04:13 AM



Page 1

Item ID: D3414-041

Accept



Setup Start



Revision ID:

Item Name: Lug Assembly

Stop



Start Date: 9/1/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 9/15/2011 Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan:

MUF

Date: 11-09-01

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3414

Rev C

100

0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3414-1

Dwg Rev: E

Prog Rev: C

304 .100

2-Deburr if necessary

B14-9-8

12

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B11-9-8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries




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Required Date:	9/15/2011	Req'd Qty:	10.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120  QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00		Sub 09/09		(X12)			
130  Brake NC Brake NC	Memo 1-Deburr 2-Form using DT8254 as per Dwg D3414	0.00 0.00		SP 11/09/12		(12)			
140  Large Fab Large Fab	Memo 1- Weld using location Jig DT9625 as per Dwg D3414 A/R S.S. welding rod Batch: M117659	0.00 0.00				EL	11-9-13	(X12)	

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Start Date:	9/1/2011	Start Qty:	10.00		Cust Item ID:	
Required Date:	9/15/2011	Req'd Qty:	10.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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150	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
									
QC	Memo	0.00							
Quality Control									

PL 11.05.13 (X12)

160	QC5- Inspect part completeness to step on W/O	0.00							
									
QC	Memo	0.00							
Quality Control									

8/26/14

(X12)

170	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
									
Powdercoat	Memo	0.00							
Powder Coating	START TIME:								
	OVEN TEMPERATURE:								
	FINISH TIME:								

3:30
400 OF
4:00

12 x 11/01/14

M 118439

W/O:		WORK ORDER CHANGES					
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Page 4

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Setup Start

Stop

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Required Date: 9/15/2011 Req'd Qty: 10.00

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

12

BR 11-9-15.

190

Identify as per dwg & Stock Location: ST 478

0.00



Packaging

Memo

0.00

Packaging

Dex

SEP 11-09-15.

200

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/9/15

MK 11-09-15

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Picklist Print

Wednesday, August 31, 2011 11:04:09 AM

Page 1

Work Order ID: 73337

Parent Item: D3414-041

Parent Item Name: Lug Assembly



Start Date: 9/1/2011

Required Date: 9/15/2011

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP A 05.09.13 New issue KJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304S12GA

Purchased

No

100

sf

141.5800

0.155

1.55

2



304/316 0.100" Sheet



18-9-8

12

Location

Loc Qty

Loc Code

MAT019

141.58

113062

118.3

113077

23.28

D3414-3

Manufactured

No

140

Each

40.0000

1

10



113077

12 11-9-12

Lug

Location

Loc Qty

Loc Code

WA030

40

72327

40

12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 73337
Description: Lug Bracket		Part Number: D3414-1
Inspection Dwg: D3414	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.313	+0.006/-0.001	0.314	✓		V B02	
1.19	+/-0.030	1.185	✓		V	
1.00	+/-0.030	1.002	✓		V	
3.38	+/-0.030	3.368	✓		V	
5.350	+/-0.010	5.351	✓		V	
6.23	+/-0.030	6.222	✓		V	
2.500	+/-0.010	2.498	✓		V	
0.37	+/-0.030	0.370	✓		V	
0.100	+/-0.010	0.103	✓		V	

Measured by: B	Audited by: J	Prototype Approval:	N/A
Date: 11-9-8	Date: 11/09/07	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.02.28	New Issue P/O D3414-041	KJ/DD	
B	09.05.27	Dimensions updated per Dwg Rev B	KJ	
C	09.10.16	Dwg Rev updated to Rev C	KJ	

W/O:		WORK ORDER CHANGES					
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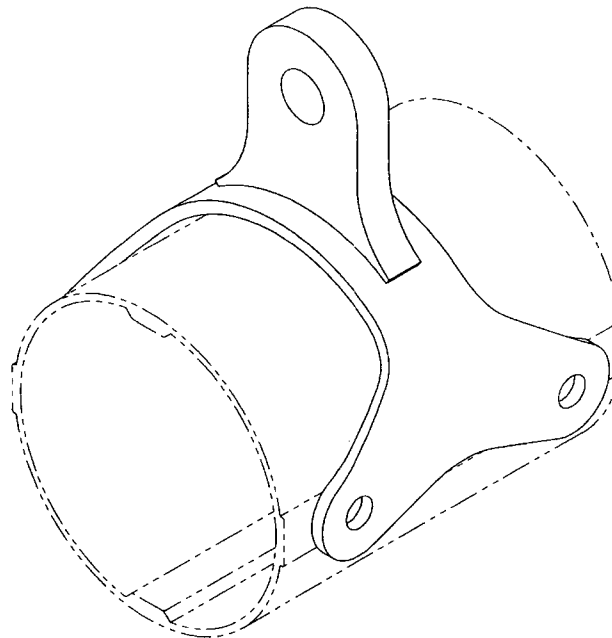
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ITEM No.	QTY. -041	PART NUMBER	DESCRIPTION
1	X	D3414-041	LUG ASSEMBLY
2	1	D3414-1	LUG BRACKET
3	1	D3414-3	LUG



D3414-041 LUG ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3414-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.52 lbs

C	BREAK SHARP EDGES FOR -3 NOW 0.030-0.060 WAS 0.010-0.030 (ZN A7-3)	CP	09.06.17
B	DRAWING REDRAWN IN SOLIDWORKS WITH CURRENT STANDARDS AND TRANSFERRED TO "B" SIZE BORDER. FLAT PATTERN FOR -1 INCREASED IN LENGTH TO PREVENT FOULING AT INSTL (SEE PAR198). FLAT SPOTS REMOVED FROM -1 (PART NOW "U" SHAPED) FOR EASE OF MANUFACTURE. B7-3 ADDED TOLERANCE TO 3.230 DIM. C2-3 1.12 DIM WAS 1.20.	AJS	08.09.23
A	NEW ISSUE	CP	05.03.16
REV.	DESCRIPTION	BY	DATE
DESIGN	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	CP		
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3414	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		LUG ASSEMBLY	NTS
DATE	09.06.17	<small>COPYRIGHT © 2005 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR QUANTIFIED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

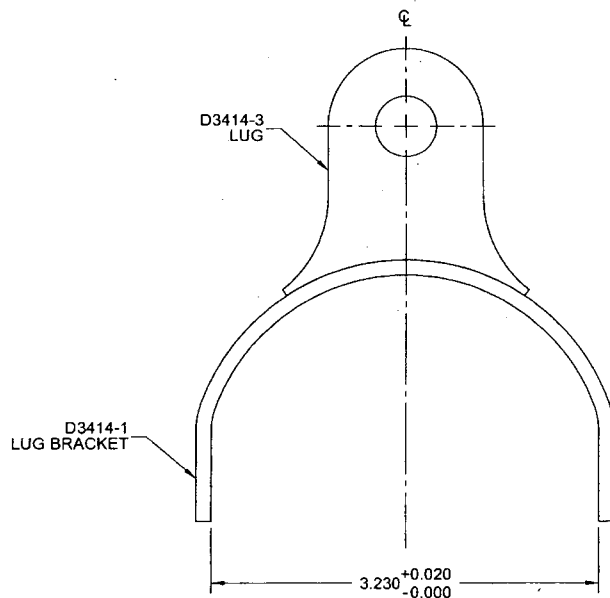
W/O:		WORK ORDER CHANGES					
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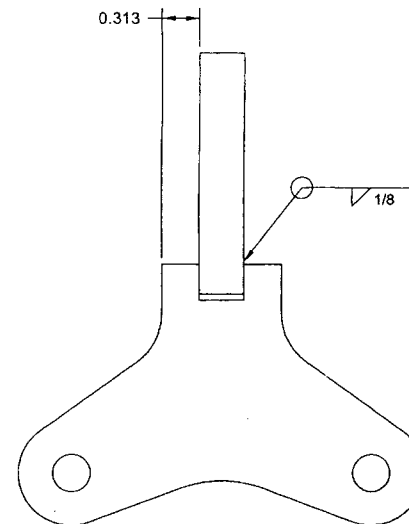
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D3414-041 LUG ASSEMBLY



73337

RELEASED

DESIGN	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	CP		
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3414	SHEET 2 OF 3
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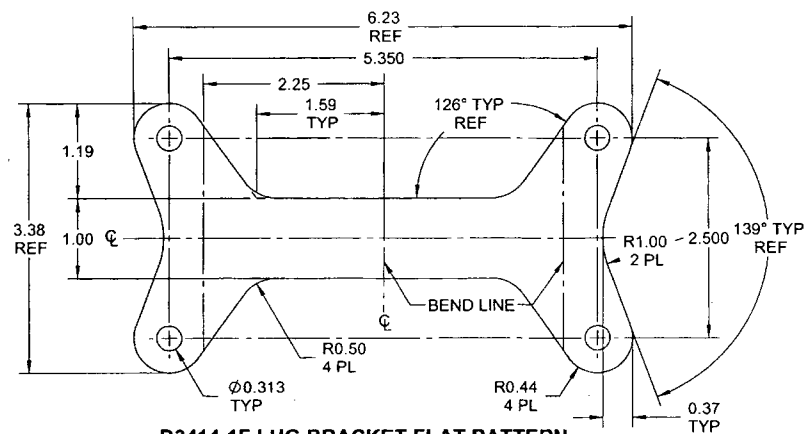
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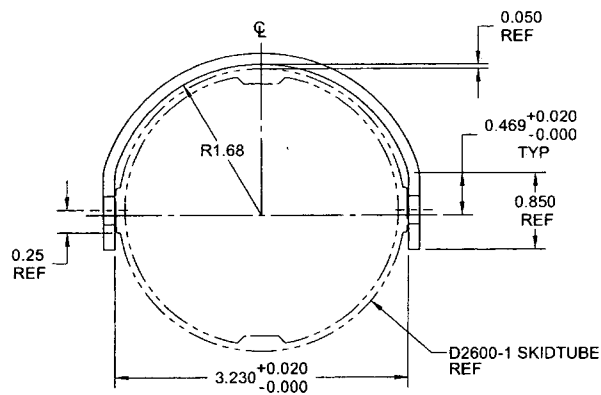
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D3414-1F LUG BRACKET FLAT PATTERN



D3414-1 LUG BRACKET

NOTES:

1) MATERIAL: -1: AISI 304/316 STAINLESS STEEL SHEET, 12 GAUGE (0.100 THICK)
PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524
REF. DART SPEC. M304S12GA

-3: AISI 304/316 STAINLESS STEEL PLATE
PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524
REF. DART SPEC. M304S

2) FINISH: N/A

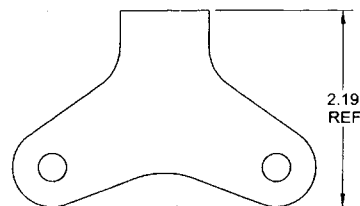
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

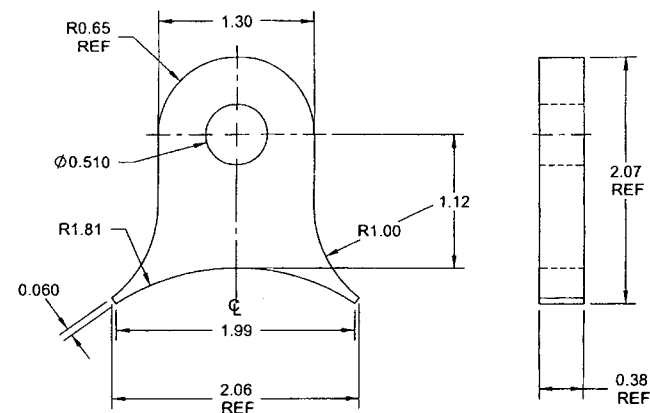
5) BREAK SHARP EDGES: -1: 0.010 TO 0.020 MAX
-3: 0.030 TO 0.060 MAX

6) IDENTIFICATION: N/A

7) WEIGHT: N/A



SIDE VIEW FOR REF ONLY



D3414-3 LUG

73337

RELEASED

DESIGN	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	CP		
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3414	SHEET 3 OF 3
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